

Date: Wednesday, 3/8/2006 10:38:19 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DUCT
Job Number	: 26118		
Estimate Number	: 12316		
P.O. Number	: N/A	Part Number	: D34733
This Issue	: 3/8/2006 S.O. No. : N/A	Drawing Number	: D3473 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 3/31/2006
Checked & Approved By	: <u>06.03.08</u>	Qty:	10 Um: Each
Comment	: Est Rev:A New Issue 06-03-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: 00000768 06/03/09
 E-mail or Ship DXF file to vendor
 Laser cut flat pattern as per Dwg D3473
 Possible supplier: Ind. Laser
 Material release note is required.

2.0	D34733F	COVER FLAT PATTERN
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Comment: Qty.: 1.0000 sf(s)/Unit Total : 6.0000 sf(s)
 FLANGE PLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

06.03.22

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06.03.22

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Form as per Dwg D3473 using DT8860

06.03.21

Q

PTC

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		one taken Ser template	VB	060327	1	VB	VB

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 06/04/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:38:19 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUCT

Job Number: 26118

Part Number: D34733

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

06/04/24

⑨

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/04/24

9

Job Completion



Level of inspection

U 06.04.25

06/04/24

⑩

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

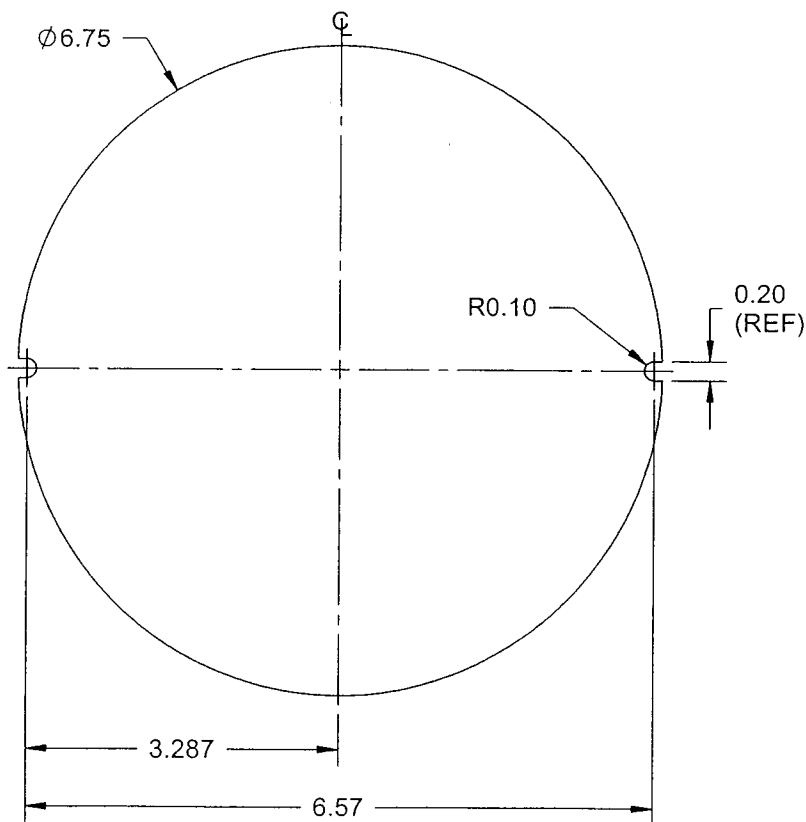
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

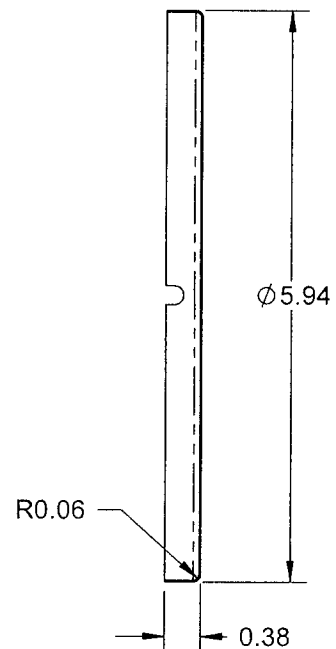
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3473	REV. A SHEET 4 OF 7
DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:2



D3473-3F COVER FLAT PATTERN



D3473-3F COVER

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

3/17/06

604-946-4153 ATTN: PETE

03/17/2006 14:36 FAX 604 946 4153
03/17/2006 14:16 FAX 6042729137INDUSTRIAL LASER CUTTING
INTEGRIS METALS002
001/004

3/17/2006 1:57 PAGE 001/002 Fax Server


Ryerson

T-726 P.007/015 F-587

253-288-9889

FROM-INTEGRIS

MAY-17-2006 10:05

		AK Steel Corporation Metallurgical Test Report Coshoccon Works Coshoccon, OH 43812		Page 1											
				Lead No. 741672 SRN No. 741672											
CUSTOMER INTEGRIS METALS PO BOX 340 MINNEAPOLIS, MN 55440	SHIP TO INTEGRIS METALS 306 B STREET ALBURN, WA 98001	MILL ORDER NO. 772185-0191 PART NO. 74251497		PROCESSOR ORDER NO. 427135-01 BUYER'S ORDER NO. 427135-01											
		EXHAUST UNITS -PRODUCT- METREC UNITS 518 NOM 48.000 X COIL													
SKD ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT											
SKD713143	1	7250151	0549919-01	2,145 LBS. 4012 KG.											
SKD713144	1	7250151	0549919-01	2,170 LBS. 4613 KG.											
SKD713145	1	7250151	0549919-01	2,125 LBS. 4083 KG.											
SKD713149	1	7250151	0549919-01	2,101 LBS. 3997 KG.											
TOTAL SKIDS	TOTAL PIECES			TOTAL NET WEIGHT											
4	4			21,441 LBS. 15,075 KG.											
L-Label Analysis of Heat P-Product Analysis of Parent Coil CHEMICAL ANALYSIS															
ID	C	MN	P	S	SI	CR	NI	MO	N	CU	CO				
L 7250151	.049	1.39	.027	.001	.35	18.18	8.05	.35	.04	.30	.12				
SHIPPING DATE: 03/13/2005 REMARKS: NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL.						PRODUCT DESCRIPTION CR SHOT TYPE 304 STAINLESS #28 FINISH SLIT EDGE * AMS 8813 & ALL TECH REQS HAVE BEEN MET UNLESS MARKED TO OR NOTED OTHERWISE * 2 SYM A 240 -04 EX PARA 3.1.1.3 ELONG WILL BE DETERMINED BY ASTM E 9 * ASTM A 490 -01 EX PARA 19.3.1.1 ELONG WILL BE DETERMINED BY ASTM H & S EX PARA 26.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY * ASTM A 566 -03 * IN-011 Rev 0, * IN-011 0 * BUYER PART# 74251497 * ASME SA-240 SECTION II PART A (2001 ED. 2002 ADDENDA) EX PARA 3.1.1.3 ELONG WILL BE DETERMINED BY ASTM E 9 * EN-10204 3.1.5									
PARENT COIL ID	FOR (E7)	OR (L, T, D)	CONC	% ELONG 2 INCH MEASURED	TENSILE STRENGTH (KSI)	YS. (KSI)	ELONG. (IN)	ROCKWELL HARDNESS (Toll)	ROCKWELL HARDNESS (Front)						
0549919-02	T	T	ASTM	71.0	105.2	77.1	72	71							
*** CONTINUED ON NEXT PAGE ***															

Fax Server

T-726 P.008/015 F-527

002/004

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 1
Heat/Lot : 86K8
TIN : B42748

Sold To: INTEGRIS METALS, LTD.
7910 40TH STREET SE
CALGARY, AB T2C2Y3

Ship To: ***CUSTOMER PICKUP***
4375 14TH STREET NORTHEAST
CALGARY
ABT3E7A9

Vendor Information

Cust PO #: 406824

Cust PO DT: 11/03/05

Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a 480/04a, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04
Q08766D-A X 1/8 FRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS
CORROSION: ASTM A262/02aE; 180Bend-OK
Buyer Part: 4288441
304 2B .1305 IN 48 IN 96 IN
Country of Origin: UNITED STATES

Mechanical Tests

		UOM	L	O	UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV			
Tensile Strength (UTS)	93.3	KSI	F	TRANSV			
Rockwell B	85		F	TRANSV			
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV			
Rockwell A	85		T	TRANSV			

Chemical Composition

C Carbon-Fct	.059	CR Chromium-Pct	18.360
CU Copper-Fct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Fct	8.150	P Phosphorus-Pct	.029
SI Silicon-Fct	.289		

Comments

MATERIAL TEST REPORT

FROM: NORTH AMERICAN STAINLESS CANADA, IN
740 INDUSTRIAL ROAD NORTH

Page : 2
Heat/Lot : 86K8
TIN : B42748

Material from Mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 Q08763F Cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

QA by ERIC HESS 02/01/2006

Miscellaneous Data

GURUPH, OMN: K123
Control #: S1C60214 Date: 03/17/06
Part #: 74271441
.135 X .48 X .96

SOLD TO: INDA. CASEA

TO 110880

510 90-324286 - 02

Callahan 3/17/06

The Chemical Analysis and Mechanical Test
data was received via EDI from the above
mentioned vendor.

INTEGRIS METALS, LTD.

0004/004
0002

INTEGRIS METALS

03/04/2006 14:18 FAX 6042729137
04/05/2015 08:27 FAX